

Date: Monday, 2/11/2008 11:38:36 AM
 User: Kim Johnston

Process Sheet

9

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : R44 BEARPAW
Job Number : 37315A	
Estimate Number : 12480	
P.O. Number :	Part Number : D35291
This Issue : 2/11/2008 S.O. No. :	Drawing Number : D3529 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : MACHINED PARTS	Drawing Revision : A
Previous Run : 31589A	Material :
Written By :	Due Date : 2/28/2008 Qty: <u>6</u> Um: Each
Checked & Approved By : <u>JA 08 02 11</u>	
Comment : Est Rev:A New Issue 06-06-28 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	MUHMWB10	UHMW 1" Black
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Comment: Qty.: 1.2796 sf(s)/Unit Total : 15.3556 sf(s)

Pick:

blank: 13.5" x 13.000" x 1.00" thick (+0.030/-0.000)

Material: Black UHMW 1"(MUHMWB10)

Batch: M105863 x 6 pcs only = 7.6776 sf(s)

J.L 08/02/25

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

1-Inspect material for defects or damage prior to machining

2-Machine as per Folio FA645 and Dwg D3529

3-Deburr

J.L 08/02/25

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.L 08/02/25

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

SF 08/02/25

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

8/3/11 500

Handwritten notes and signatures:

- Handwritten "3" in a circle.
- Handwritten "out of stock" written vertically.
- Handwritten "X6" and "X12" in circles.

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 08/03/12
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 2/11/2008 11:38:36 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: R44 BEARPAW

Job Number: 37315A

Part Number: D35291

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



(6)

Comment: FINAL INSPECTION/W/O RELEASE

02/03/12

Job Completion



2008/3/11

(6)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 37315A
Description: Bearpaw		Part Number: D3529-1
Inspection Dwg: D3529	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

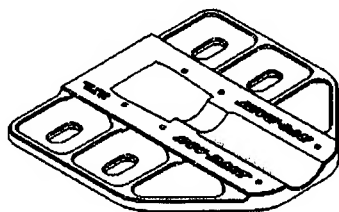
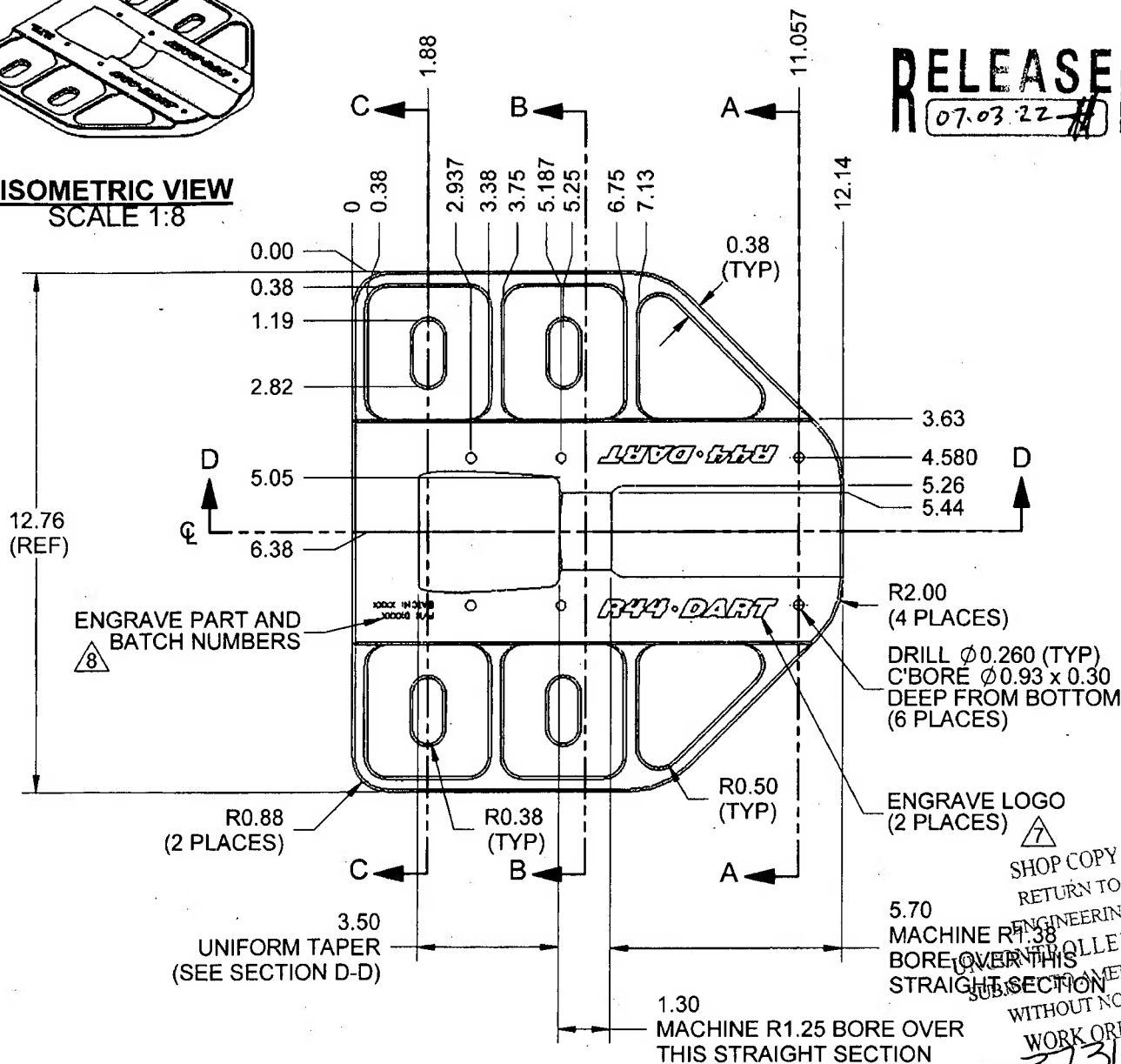
Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	5.50	+/-0.030	5.500 ✓			
B	0.07 x 45°	+/-0.030 x 0.5°	0.073x45° ✓			
C	R0.25	+/-0.030	0.25 ✓			
D	0.250	+/-0.010	0.251 ✓			
E	0.625	+/-0.010	0.624 ✓			
F	0.950	+/-0.010	0.956 ✓			
G	1.63	+/-0.030	1.620 ✓			
H	12.14	+/-0.030	12.14 ✓			
I	10.50	+/-0.030	10.530 ✓			
J	5.70	+/-0.030	5.710 ✓			
K	0.375	+/-0.010	0.378 ✓			
L	0.525	+/-0.010	0.526 ✓			
M	0.13 x 45°	+/-0.030 x 0.5°	0.116x45° ✓			
N	R0.50	+/-0.030	0.50 ✓			
O	12.76	+/-0.030	12.76 ✓			
P	3.38	+/-0.030	3.38 ✓			
Q	3.75	+/-0.030	3.752 ✓			
R	5.187	+/-0.010	5.187 ✓			
S	5.25	+/-0.030	5.252 ✓			
T	7.13	+/-0.030	7.129 ✓			
U	Ø0.260	+0.006/-0.001	0.260 ✓			
V	0.30	+/-0.030	0.308 ✓			
W	0.93	+/-0.030	0.928 ✓			
X	1.30	+/-0.030	1.298 ✓			
Y						

Measured by: SL	Audited by: JF	Prototype Approval:	N/A
Date: 08/02/25	Date: 08/02/25	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.05.01	New Issue	KJ/JLM	

DART

DESIGN CB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3529	REV. A SHEET 1 OF 2
DATE 07.01.04		TITLE R44 BEARPAW	SCALE 1:4
REV A	DATE 07.01.04	DESCRIPTION NEW ISSUE	

RELEASED
07.03.22**ISOMETRIC VIEW**
SCALE 1:8**D3529-1 R44 BEARPAW****NOTES:**

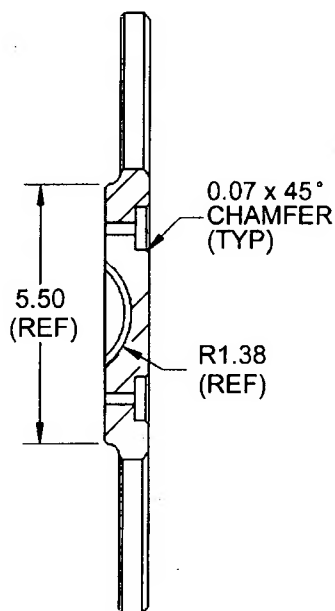
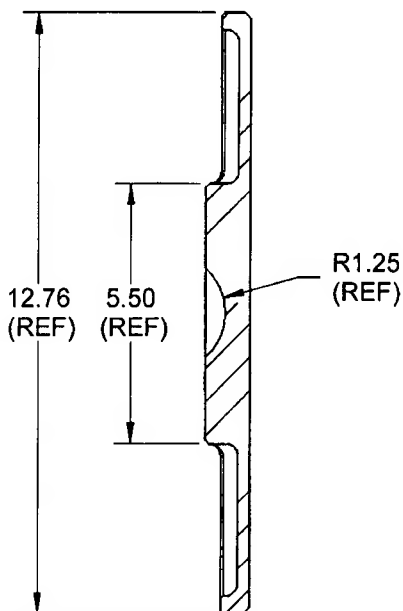
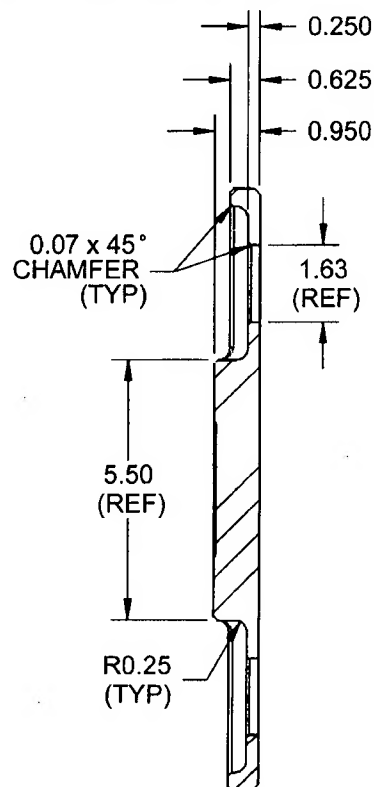
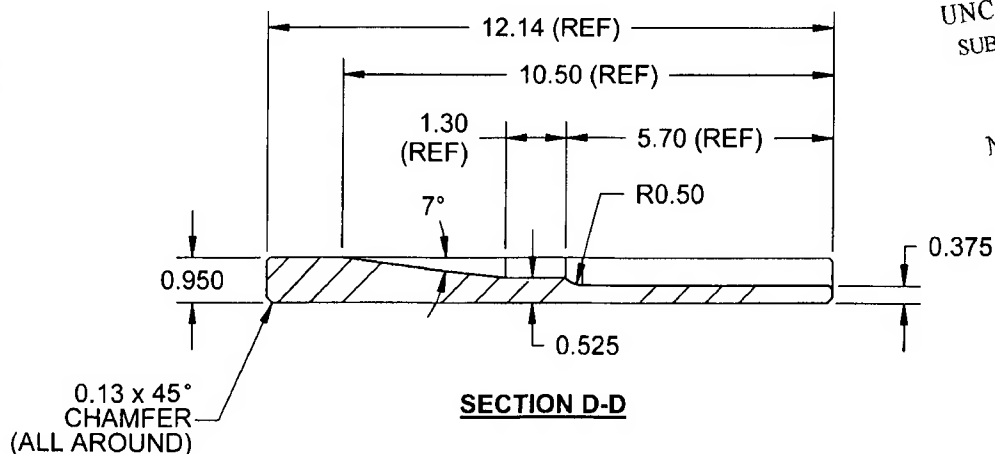
- 1) MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689, 1.00 THICK (MACHINE TO 0.950)
- 2) FINISH: NONE
- 3) PART IS SYMMETRIC ABOUT ϕ
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) ENGRAVE LOGO TO MAX DEPTH OF 0.012 AT LOCATION SHOWN
- 8) ENGRAVE PART AND BATCH NUMBERS TO MAX DEPTH OF 0.010 AT LOCATION SHOWN

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DART

DESIGN CB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3529	REV. A SHEET 2 OF 2
DATE 07.01.04		TITLE R44 BEARPAW	SCALE 1:4

RELEASED
07.03.22**SECTION A-A****SECTION B-B****SECTION C-C****SECTION D-D**

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WITHOUT NOTICE
WORK ORDER
NO. 37315A

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